

Work Order ID 64204

Tuesday, November 30, 2010 11:25:29 AM



Page 1

Item ID: D3970-3KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Fire Extinguisher Cover w/o Duct

Start Date: 11/30/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3970

B

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x 2

Dh
10/12/21

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

x 2

Dh
10/12/21

Temp: 150 F

Time IN: 4:30 pm 10/12/20

Time OUT: 7:00 am 10/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA082 using tool DT9329
Dwg Rev: B
Folio Rev: A

2

Ph
10/12/21

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

2

M
10/12/21

130

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

2

B
10/12/21

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Page 3

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Start Date: 11/30/2010 Start Qty: 2.00

Required Date: 12/14/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Hand Thermo

Memo

0.00

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x 2

Dh
10/12/20

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

Complete FAI document

x 2

Dh
10/12/20

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Sulor/s

(+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4



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Required Date: 12/14/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

APP 64205

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

C 11/01/03 (2)

OK 11/01/04

W 11.01.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, November 30, 2010 11:25:28 AM

Work Order ID: 64204



Parent Item: D3970-3KGY



Parent Item Name: Fire Extinguisher Cover w/o Duct

Start Date: 11/30/2010

Required Date: 12/14/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev. A New Issue 10/11/30 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	393.5600	3.84	7.718593			



Kydex steel grey

Location

Loc Qty

Loc Code

therm

393.56

393.56

111807

2.718593 sq ft.

DL
10/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

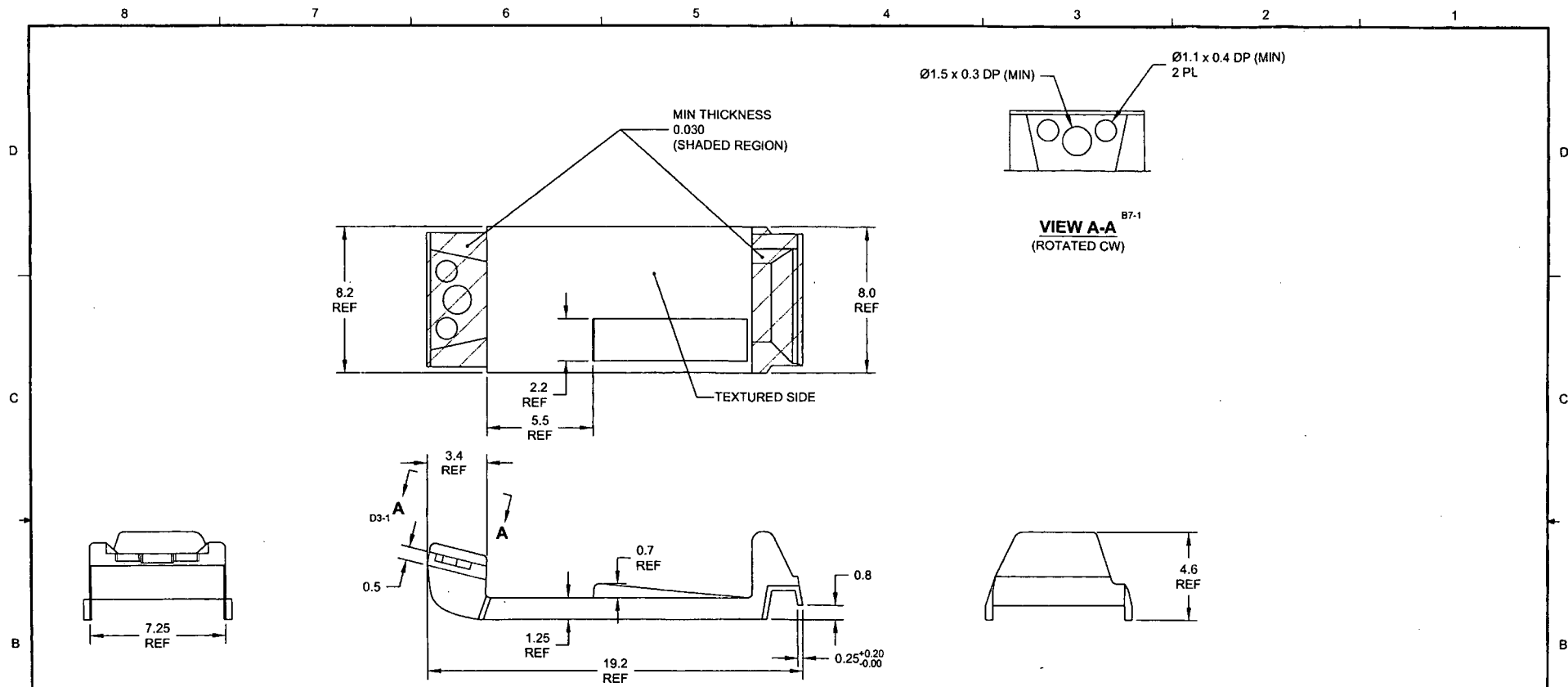
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

64204



D3970-1 COVER, W/ FLASHLIGHT HOLDER

RELEASED
2010-11-24

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N (SEE TABLE) PER DART QSI 044 6.4
- 7) WEIGHT: 0.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9323 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.045" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3970-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3970-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

B	ADDED D3970-3	SC	10.11.05
A	NEW ISSUE	PH	09.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3970	REV. B SHEET 1 OF 2
TITLE COVER, W/ FLASHLIGHT HOLDER	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

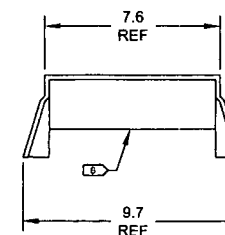
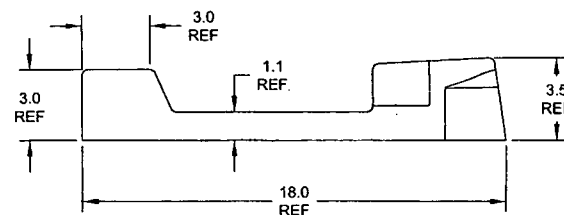
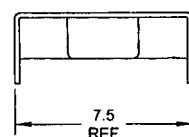
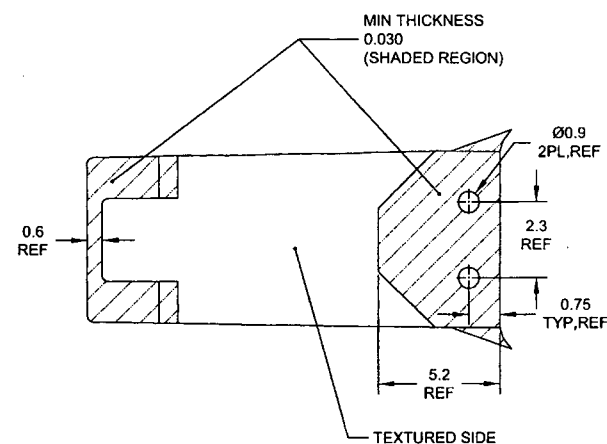
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

604204







D3970-3 FIRE EXTINGUISHER COVER W/O DUCT

RELEASED
2010-11-24

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N (SEE TABLE) PER DART QSI 044 6.4
- 7) WEIGHT: 0.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9329 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.045" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3970-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3970-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3970	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		COVER, W/ FLASHLIGHT HOLDER	NTS
DATE	10.11.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 64204
Description: FIRE EXT COVER	Part Number: D3970-3K6Y
Inspection Dwg: D3970 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BD

Date: 10/01/03

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.0	REF	18	✓			
7.5	REF	7.375	✓			
9.7	REF	9.6	✓			
1.1	REF	1.09	✓			
3.0	REF	3.0	✓			
3.5	REF	3.5	✓			
0.030	Min	0.069	✓			
0.045	Min	0.066	✓			

Measured by: BD

Date: 10/01/03

Audited by: 8

Date: 11/01/03

Preliminary Approval: _____

Date: _____

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14